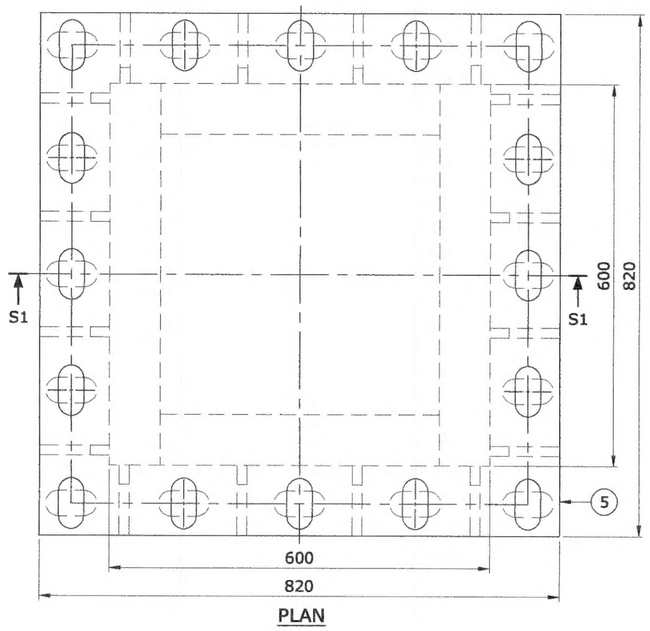
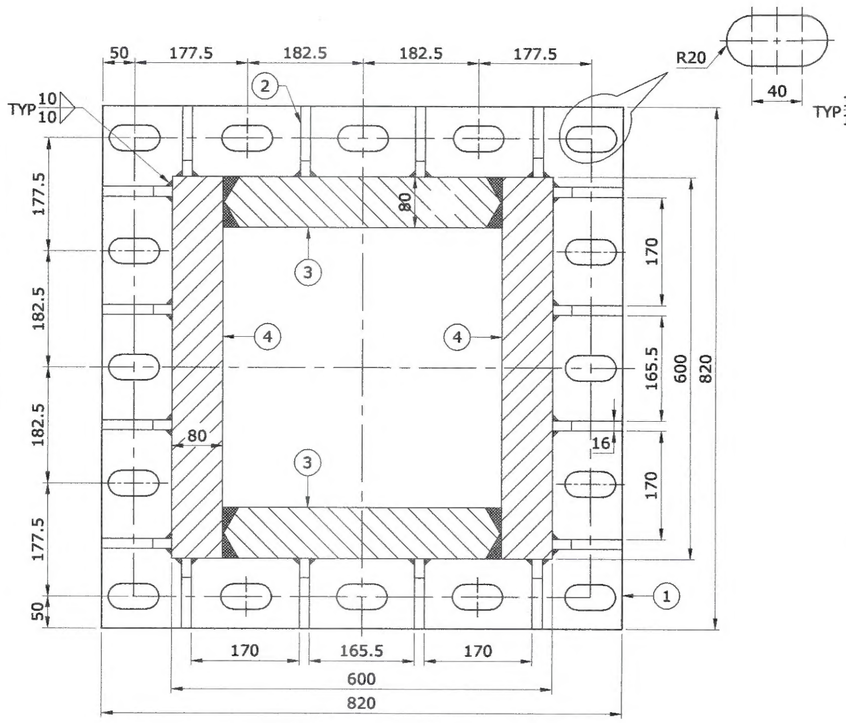
REF. DRG. NO.10-STR-12-1-23/A2

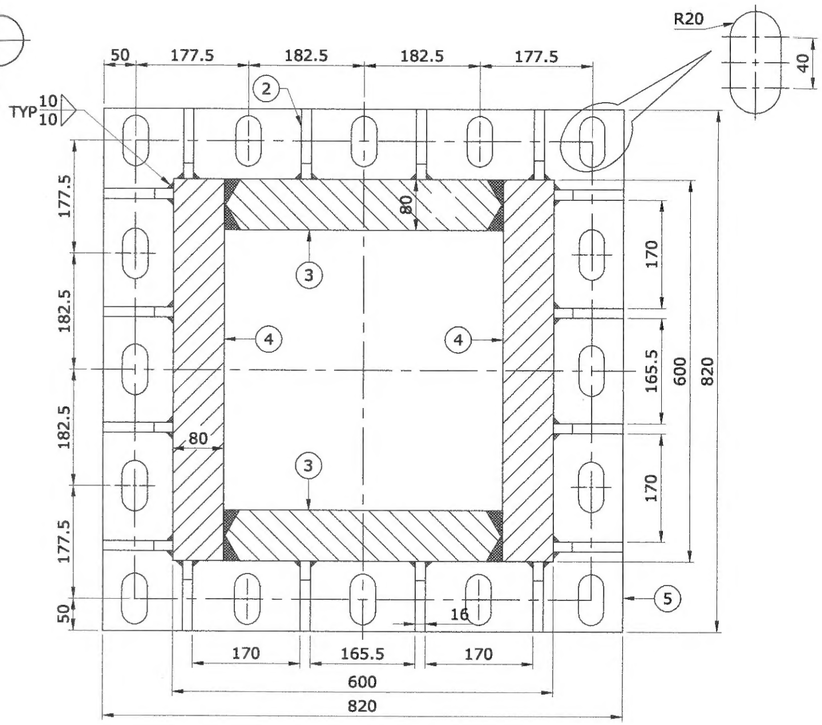
COM. FILE NO.SCEND/AG80/A2/2023/SREENU.P/KUMAR



PLAN



SECTION : S2-S2



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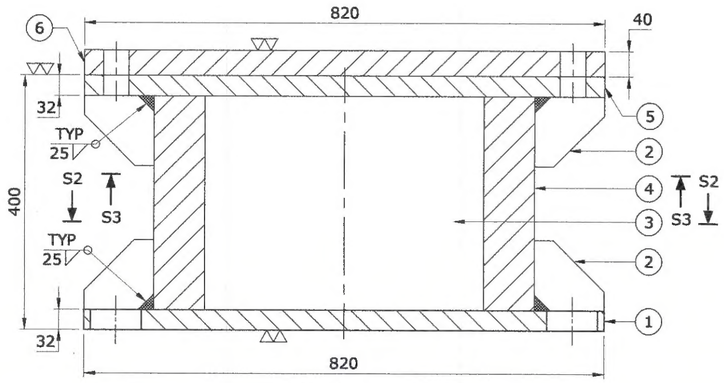
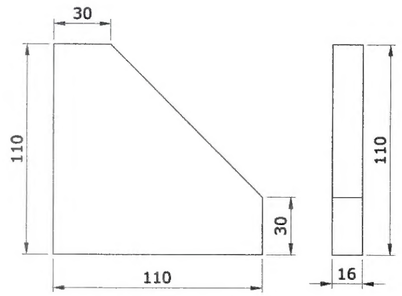


SECTION : S1-S1



PART NO : 2

NOTES:-

1. ALL DIMENSIONS SHOWN ARE FINISHED DIMENSIONS.
2. ALL PLATES ABOVE 20mm THICK SHALL BE UT TESTED.
3. ALL WELDS ARE OF 10mm SIZE FILLET UNLESS OTHERWISE SPECIFIED.
4. ALL WELDS ARE TO BE DP TESTED FOR ROOT AND FINAL PASSES TO ENSURE WELD QUALITY.
5. ALL BUTT WELD JOINTS SHALL BE 100% R.T CHECKED.
6. FINAL MACHINING SHALL BE CARRIED OUT AFTER STRESS RELIEVING.
7. HOLES TO BE TRANSFER WITH PART NO: 5 TO PART NO : 6.
8. CHECK THE STATUS OF THE DRAWING BEFORE STARTING FABRICATION.

TOTAL WEIGHT 1036 kg(Approx.)

S.NO	DESCRIPTION	MATERIAL	QTY	W.T	REMARKS
6	BEARING PLATE 820 x 820 x 40Thk	IS : 2062 E250 Gr : B	1	211	
5	PLATE 820 x 820 x 32Thk	IS : 2062 E250 Gr : B	1	169	
4	PLATE 600 x 336 x 80Thk	IS : 2062 E250 Gr : B	2	253	
3	PLATE 440 x 336 x 80Thk	IS : 2062 E250 Gr : B	2	186	
2	STIFFENER 100 x 110 x 16Thk	IS : 2062 E250 Gr : B	32	49	
1	PLATE 820 x 820 x 32Thk	IS : 2062 E250 Gr : B	1	169	

STATUS	SIGN	DATE
DISCUSSION / REVIEW		
TENDER PURPOSE		9/10/23
FABRICATION		

UNRESTRICTED | RESTRICTED | CONFIDENTIAL

DO NOT SCALE THE DRAWING
ASK IF IN DOUBT
UNLESS OTHERWISE SHOWN
ALL DIMENSIONS ARE IN MILLIMETERS
REMOVE SHARP EDGES & BURRS
CHAMFER 1 M.M. X 45°
MACHINING FINISH IN MICRONS :-
▽ 6 - 25 ▽▽ 1.6 - 8
▽▽▽ 0.025 - 1.6 ▽▽▽▽ < 0.025

DEVIATION FOR NON TOLERANCED DIMENSIONS (IS -2102)

DIAMETERS & LENGTHS	
UPTO & INCL.	6 ±0.1
6 -	30 ±0.2
30 -	120 ±0.3
120 -	315 ±0.5
315 -	1000 ±0.8
1000 -	2000 ±1.2
2000 -	4000 ±2.0
4000 & ABOVE	±3.0

LENGTH IN M.M. OF SHORTER SIDE OF ANGLE UPTO & INCL.	
1-	6 ± 1°-00'
6-	30 ± 0°-30'
30-	120 ± 0°-20'
120-	400 ± 0°-10'

SCEND
SHAR CENTRAL DESIGNS

	SIGN.	DATE
DESIGNED		
DES.CHKD		
DRAWN	SREENU.P	09-10-23
DRG.CHKD		9/10/23
APPROVED		

TITLE
GROUND ANCHOR DETAILS FOR MLS (SLC PROJECT)

GOVERNMENT OF INDIA
INDIAN SPACE RESEARCH ORGANISATION
SATISH DHAWAN SPACE CENTRE SHAR
SRIHARIKOTA

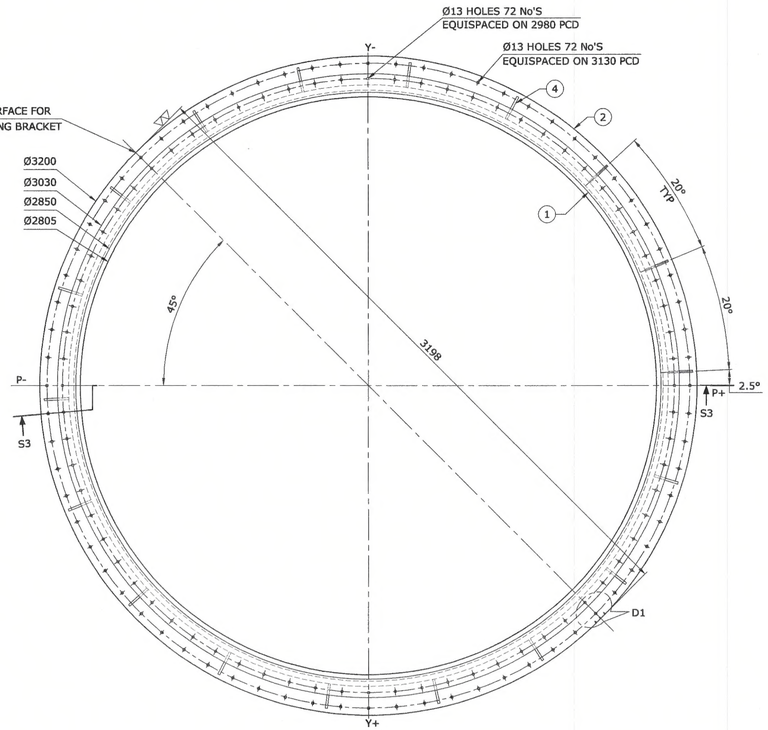
PROJECTION

SCALE 1 : 10

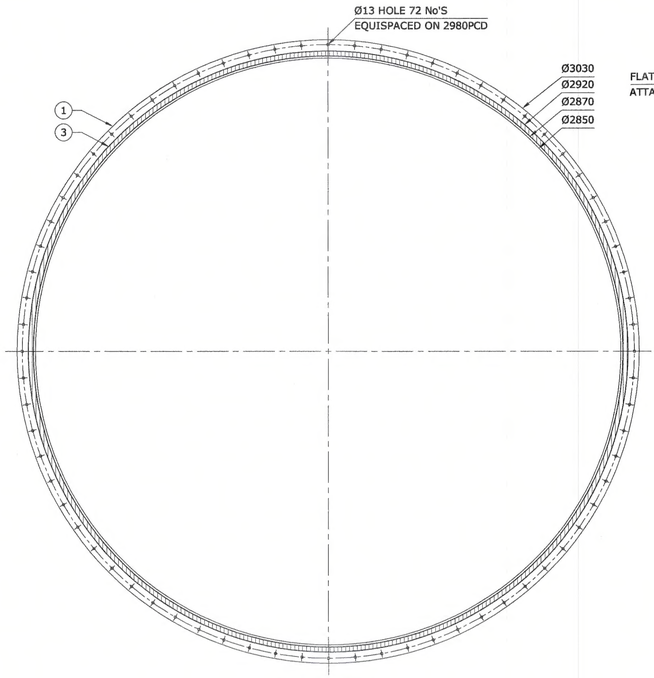
DRG. NO. 10-STR-12-1-23/A2

SHEET 13 OF 14

REF. DRG. NO. 10-STR-12-1-23/A1
COM. FILE NO.SCEND/AG80/A1/2023/SREENU.P/KUMAR

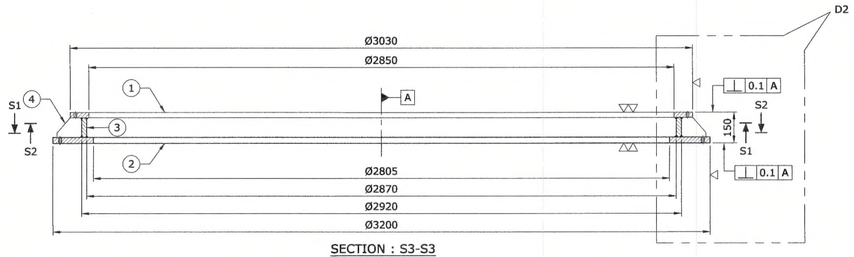


PLAN

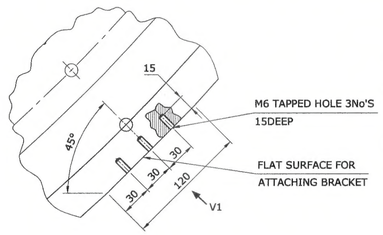


SECTION : S1-S1
(WITHOUT SHOWING STIFFENERS)
TOP ANNULAR PLATE

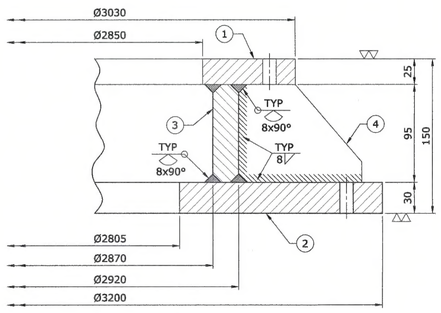
SECTION : S1-S1
(WITHOUT SHOWING STIFFENERS)
BOTTOM ANNULAR PLATE



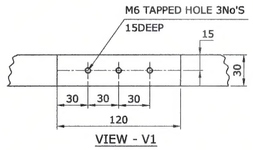
SECTION : S3-S3



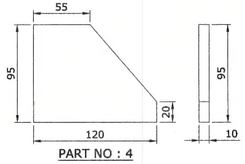
DETAIL - D1



DETAIL : D2



VIEW - V1



PART NO : 4

NOTE :

1. ALL DIMENSIONS SHOWN ARE FINISHED DIMENSIONS.
2. ALL THE WELDS ARE OF 8 mm SIZE FILLET UNLESS OTHERWISE SPECIFIED.
3. THE WELDS ARE TO BE DP TESTED FOR ROOT AND FINAL RUNS TO ENSURE WELD QUALITY.
4. ALL PLATES ABOVE 20mm THICK SHALL BE UT TESTED.
5. STRESS RELIEVING SHALL BE CARRIED OUT BEFORE FINAL MACHINING.
6. PART NO : 2 INTERFACE SHALL BE PROVIDED ON TOP OF MLP-CAS.
7. M12 FASTENERS WITH 8.8 PROPERTY CLASS SHALL BE USED FOR CONNECTING WITH CAS.
8. PART NO-1, 2 & 3 SHALL BE MADE WITH TWO OR THREE PIECES ONLY.
9. ALL BUTT WELDS SHALL BE OF 100% RADIOGRAPHED.
10. REQUIRED SIZES SHALL BE ARRIVED TAKING INTO CONSIDERATION OF FABRICATION ALLOWANCE.
11. CHECK THE STATUS OF THE DRAWING BEFORE STARTING FABRICATION/MACHINING.

TOTAL WEIGHT 804 kg(Approx.)

S.NO	DESCRIPTION	MATERIAL	QTY	W.T	REMARKS
4	STIFFENER 120 x 95 x 10Thk	IS : 2062 E250 Gr : B	36	32	
3	SHELL OD2920 x ID2870 x 95Height	IS : 2062 E250 Gr : B	1	170	
2	BOTTOM ANNULAR RING OD3200 x ID2805 x 30Thk	IS : 2062 E250 Gr : B	1	439	
1	TOP ANNULAR RING OD3030 x ID2850 x 25Thk	IS : 2062 E250 Gr : B	1	163	

STATUS	SIGN	DATE
DISCUSSION / REVIEW		
TENDER PURPOSE		9/10/23
FABRICATION		

UNRESTRICTED | RESTRICTED | CONFIDENTIAL

DO NOT SCALE THE DRAWING
ASK IF IN DOUBT
UNLESS OTHERWISE SHOWN
ALL DIMENSIONS ARE IN MILLIMETERS
REMOVE SHARP EDGES & BURRS
CHAMFER 1 M.M. X 45°
MACHINING FINISH IN MICRONS :-
▽ 8 – 25 ▽▽ 1.6 – 8
▽▽▽ 0.025 – 1.6 ▽▽▽▽ < 0.025

DEVIATION FOR NON TOLERANCED DIMENSIONS (IS –2102)

DIAMETERS & LENGTHS	LENGTH IN M.M. OF SHORTER SIDE OF ANGLE UPTO & INCL.
UPTO & INCL. 6 ±0.1	
6 – 30 ±0.2	
30 – 120 ±0.3	1– 6 ± 1°–00'
120 – 315 ±0.5	6– 30 ± 0°–30'
315 – 1000 ±0.8	30–120 ± 0°–20'
1000 – 2000 ±1.2	120–400 ± 0°–10'
2000 – 4000 ±2.0	
4000 & ABOVE ±3.0	

SCEND
SHAR CENTRAL DESIGNS

	SIGN.	DATE
DESIGNED		
DES.CHKD		
DRAWN	SREENU.P	09-10-23
DRG.CHKD		9/10/23
APPROVED		

TITLE
INTERFACE RING FOR MLS
(SLC PROJECT)

GOVERNMENT OF INDIA
INDIAN SPACE RESEARCH ORGANISATION
SATISH DHAWAN SPACE CENTRE SHAR
SRIHARIKOTA

PROJECTION

SCALE 1 : 15
DRG. NO. 10-STR-12-1-23/A1
SHEET 14 OF 14